Date:

Tuesday, 15/08/2006 7:17:42 AM

User: Linda Lacelle

Process Sheet

Customer **Job Number** : CU-DAR001 Dart Helicopters Services

Estimate Number

: 28163

P.O. Number This Issue

Prsht Rev.

First Issue

: 10518 : NA

: 15/08/2006

S.O. No. : NA

: MACHINED PARTS Type

: 27286 **Previous Run**

Written By

Checked & Approved By

Comment

05.03.11

Part now turned

KJ/JLM

: D28063 **Part Number**

Drawing Number

Drawing Name

: D2806 REV A : N/A

: BUSHING

Project Number **Drawing Revision**

Material : 08/09/2006 **Due Date**

Each

Additional Product

Job Number:



Seq. #:

Description:

1.0

M6061T6H1000

6061-T6 1" HexBar



Comment: Qty.: 0.0962 f(s)/Unit Total: 1.9236 f(s)

6061-T6 Hex Bar 1.0"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar

(M6061T6H1.000)

Batch: M100120

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA105 and Dwg D2806

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2-Tumble

Machined Manually

3.0

QC2



21

4.0

MILLING CONV.

Comment: CONVENTIONAL MILLING MACHINE

Drill as per Dwg D2806

QC8

5.0

Comment: SECOND CHECK

Dart Aerospace Ltd

W/O:		WORK ORDER	CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						·	
Part No) :	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC	of NC Corrective Action Section B	Verification	A	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
						'		
							is	

NOTE: Date & initial all entries

Tuesday, 15/08/2006 7:17:42 AM Date: User: Linda Lacelle **Process Sheet** Drawing Name: BUSHING Customer: CU-DAR001 Dart Helicopters Services Job Number: 28163 Part Number: D28063 Job Number: **Description:** Seq. #: **Machine Or Operation:** HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 QC3 Comment: INSPECT ALODINE PACKAGING RESOURCE #1 PACKAGING 1 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock 06/08/25 8 Location: ST38 DOCUMENT CONTROL 9.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES			-																	
DATE	STEP PROCEDURE CHANGE			PROCEDURE CHANGE By Date C	By Date		PROCEDURE CHANGE By D		PROCEDURE CHANGE By D	PROCEDURE CHANGE By Da	PROCEDURE CHANGE By Date	EP PROCEDURE CHANGE By Date	EP PROCEDURE CHANGE By Date		STEP PROCEDURE CHANGE By Date	By Date	PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By		Date Qty		Approval QC Inspector
Part No	:	PAR #: Fault Category: NCI	R: Yes	No DQA	: £	Date:	06/08/08															
			ΟΛ.	N/C Closed	1.	Dotos																

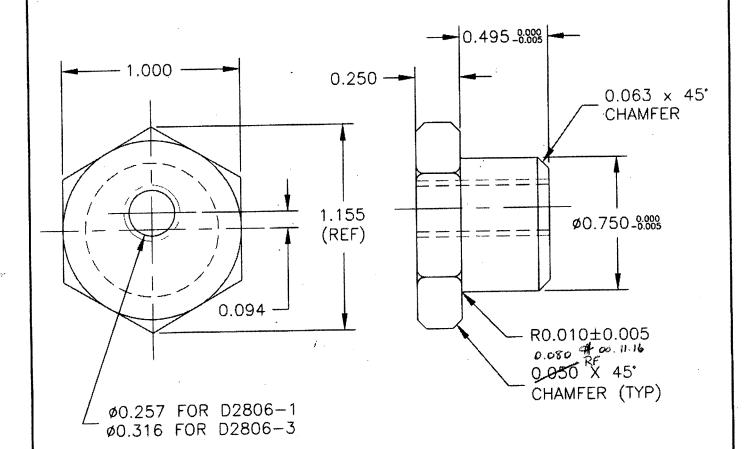
NCR: WORK ORDER NON-CONFORMANCE (NO						NCR:		CE (NCR)			
		STED Description of NC		Corrective Action Section B		Varification		Annroval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
						:					

NOTE: Date & initial all entries





Ì	DESIGN	#	DRAWN BY		AEROSPACE LTD	
١	CHECKE	ED _	APPROVED	DRAWING NO.		REV. A
•		P	A	D2806	SHEET	1 OF 1
	DATE		1 6	TITLE		SCALE
	00.1	1.08		BUSHING		2:1
-	A		00.11.08	NEW ISSUE		



REFERENCE ONLY

D2806-1 (DRILL Ø0.257 HOLE) D2806-3 (DRILL Ø0.316 HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	
Description: Bushing	Part Number:	D2806-3
Inspection Dwg: D2806 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1,005				
1.155	+/-0.010	1.145				
0.250	+/-0.010	.252				
0.063 x 45°	+/-0.010	.063 x45°				
0.080 x 45°	+/-0.010	.080K450				
0.495	+0.000/-0.005	,495				
0.750	+0.000/-0.005	,750				
Ø0.316	+0.005/-0.000	,316				
		·				
	·					
						W-10-1
		•				
		•				

Measured by:	Audited by: \(\square\)	Prototype Approval:	N/A
Date: 06/09/23	Date: 06/08/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.02.25	New Issue	KJ/RF	

Friday, 25/08/2006 9:12:40 AM

User:

Linda Lacelle

Process Sheet

Customer

Job Number **Estimate Number** : CU-DAR001 Dart Helicopters Services

: 28163

P.O. Number

This Issue Prsht Rev.

: 10518

: NC

: 25/08/2006

S.O. No. :

: 15/08/2006

: MACHINED PARTS Type

: 27286 **Previous Run**

Written By

First Issue

Checked & Approved By

Comment

: Est:B 05.03.11 Part now turned KJ/JLM

Drawing Name : BUSHING

Part Number

: D28063

Drawing Number

D2806 REV A : N/A

Project Number

: A **Drawing Revision**

Material **Due Date**

: 08/09/2006

Qty:

20 Um:

Each

Additional Product

Job Number:



Sea. #:

Machine Or Operation:

Description:

6061-T6 1" HexBar

M6061T6H1000 1.0

Comment: Qty.:

0.0962 f(s)/Unit Total:

1.9236 f(s)

6061-T6 Hex Bar 1.0"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar

(M6061T6H1.000)

Batch:

2.0

3.0

LATHE CONV.

CONVENTIONAL LATHE

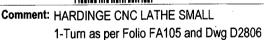


Comment: CONVENTIONAL LATHE

HARDINGE

HARDINGE CNC LATHE SMALL





2-Tumble

QC2 4.0

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE

Drill as per Dwg D2806

Date:

Friday, 25/08/2006 9:12:40 AM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 28163

Part Number: D28063

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SECOND CHECK



Comment: SECOND CHECK

HAND FINISHING RESOURCE #1



7.0

HAND FINISHING1

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

QC3 8.0

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

10.0

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

